

Date: Wednesday, 18/03/2009 7:47:39 AM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: STEP WELDMENT
<b>Job Number</b>	: 46551		
<b>Estimate Number</b>	: 12576		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D3562041
<b>This Issue</b>	: 18/03/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3562 REV E
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 46347	<b>Drawing Revision</b>	: E
	<b>Type</b> : LARGE FAB ASSY	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 25/03/2009
<b>Checked &amp; Approved By</b>	: <u>MF 09-03-18</u>	<b>Qty:</b>	4 Um: Each
<b>Comment</b>	: Est Rev:A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC verified by: DD Est Rev:C ECN1048 07-12-18 DD verified by:ec Est Rev:D 08-07-28 add chemical conversion coat DD verified by:EC Est Rev:E 09-02-27 (seq13) QC9 to QC10 DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2622120C	Step Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B44064

Check Material for any Dents or Defects

SAD 09-03-18 4

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SAD 09-03-18 4

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SAD 09/03/18 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 46551

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 09-03-18

4

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-19

4

6.0

D3560041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

ARM WELDMENT

Batch: 344471

09-03-20

4

7.0

D3560043

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

ARM WELDMENT

Batch: 344473

09-03-20

4

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total: 128.0000 Each(s)

Blind Rivet

batch: M110523

09-03-20

4

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

\*\*\*\*\*Ensure to wipe off any excess magnabond \*\*\*\*\*

A/R Magnabond 6398

Batch: M109900

09-03-20

4

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Drawing Name: STEP WELDMENT

Job Number: 46551

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/03/25 (4424)

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

343535

16.09.03.24 4

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod 1110130

2-Grind end cap welds flush as per Dwg D3562

16.09.03.25 4

16.09.03.25 4

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

PD 09.03.29

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/03/30 (4424)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1110939

16.09.03.30 (4)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:15

OVEN TEMPERATURE:

300

FINISH TIME:

8:45

UMD/FL

09/03/31

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M1109917

922

09-03-31

x4

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PK 09-03-31

4x

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

G-A

09/04/03

4

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/06

Job Completion



MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

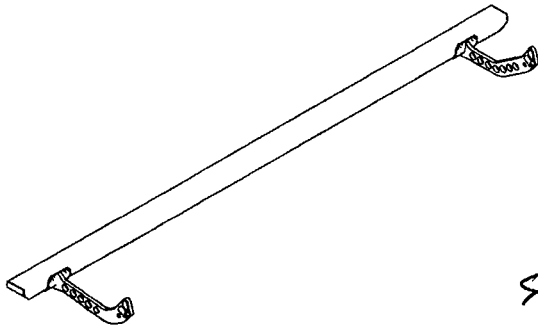
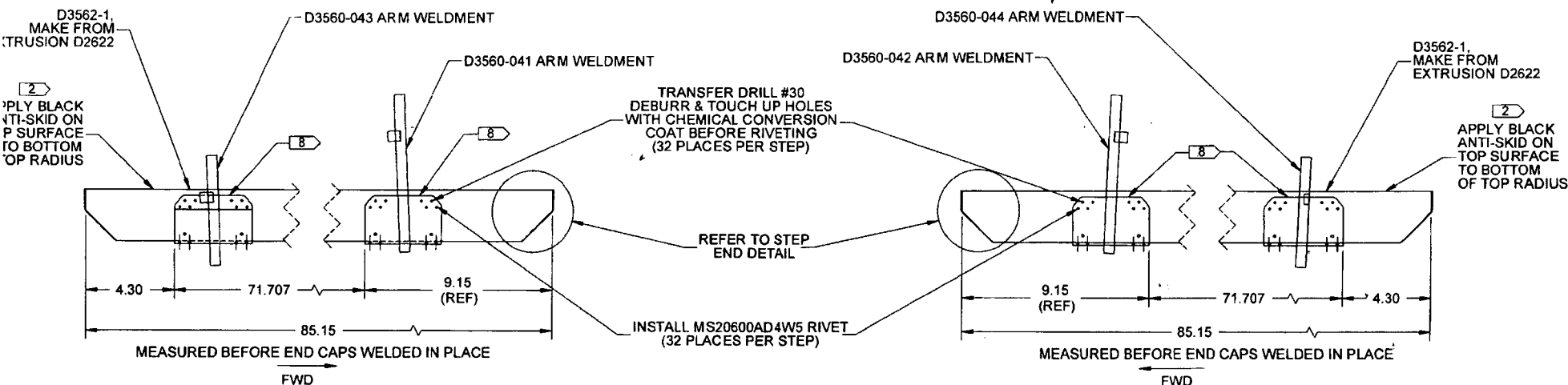
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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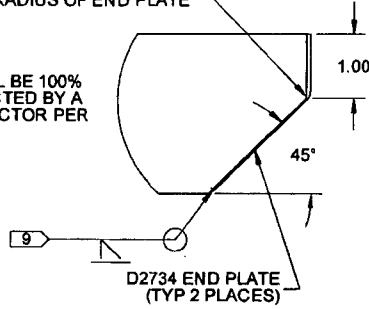




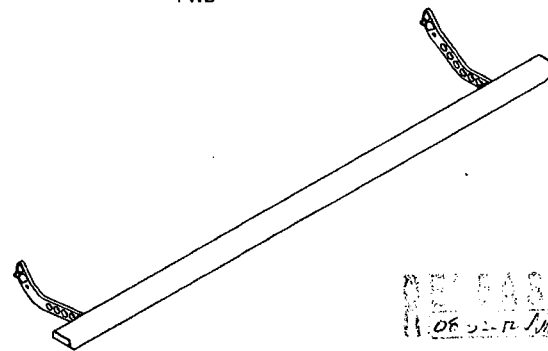
**D3562-041 LH STEP ASSEMBLY**

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



**TYPICAL STEP END DETAIL**  
SCALE 1:2



**D3562-042 RH STEP ASSEMBLY**

FINISH: MATERIAL: N/A  
FINISH:  
i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY  
ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3  
iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
UNITS: INCHES UNLESS OTHERWISE NOTED  
BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
IDENTIFICATION: NONE  
WEIGHT: 8.79 lbs  
INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.  
WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2806 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	gp	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	sf		
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.		D3562	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	1:5
DATE	08.01.11	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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